

Work Order ID 61652

Tuesday, August 31, 2010 9:50:32 AM



Page 1

Item ID: D3065-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Leg

Start Date: 8/31/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 9/7/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

14

Date:

10-8-31

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3065	Rev B								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D
necessary☐Dwg Rev:B☐Prog Rev:B☐2-Deburr if

6061 . 08D

10-9-21

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

10-9-21

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8/10/09/2210-9-21
720

Work Order ID 61652

Tuesday, August 31, 2010 9:50:32 AM



Page 3

Item ID: D3065-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Leg

Start Date: 8/31/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 9/7/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/09/28 [Signature]
C21019128

Picklist Print

Tuesday, August 31, 2010 9:50:37 AM

Page 1

Work Order ID: 61652



Parent Item: D3065-5



Parent Item Name: Step Leg

Start Date: 8/31/2010

Required Date: 9/7/2010

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP: ☐C☐02.11.01☐Incorporated D3066-1 IPP☐KJ/RF
IPP Rev:D Now on Water Jet 06-04-11 JLM
IPP Rev:E Now manufactured with 6061-T6 06-05-25 JLM☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased	No			100	sf	33.7512	1.0798	22.73263			



6061-T6 .080 Sheet



B10-9-21

Location

Loc Qty

Loc Code

MAT21

33.7512

113438

0.3512

115389

33.4

115689

115689

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

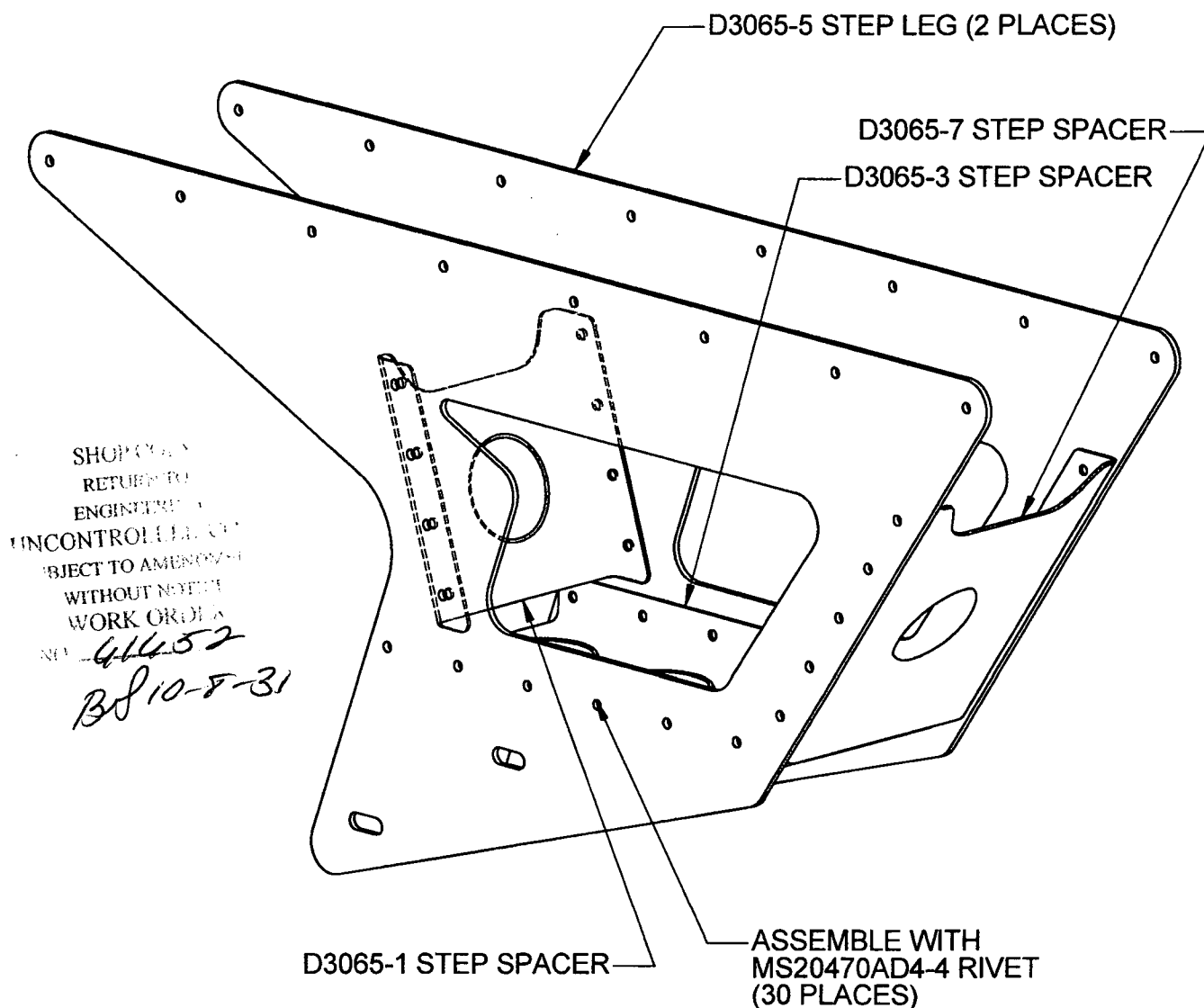
NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 1 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:2
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

RELEASED

06.06.20 *[Signature]*



D3065-041 STEP LEG ASSEMBLY

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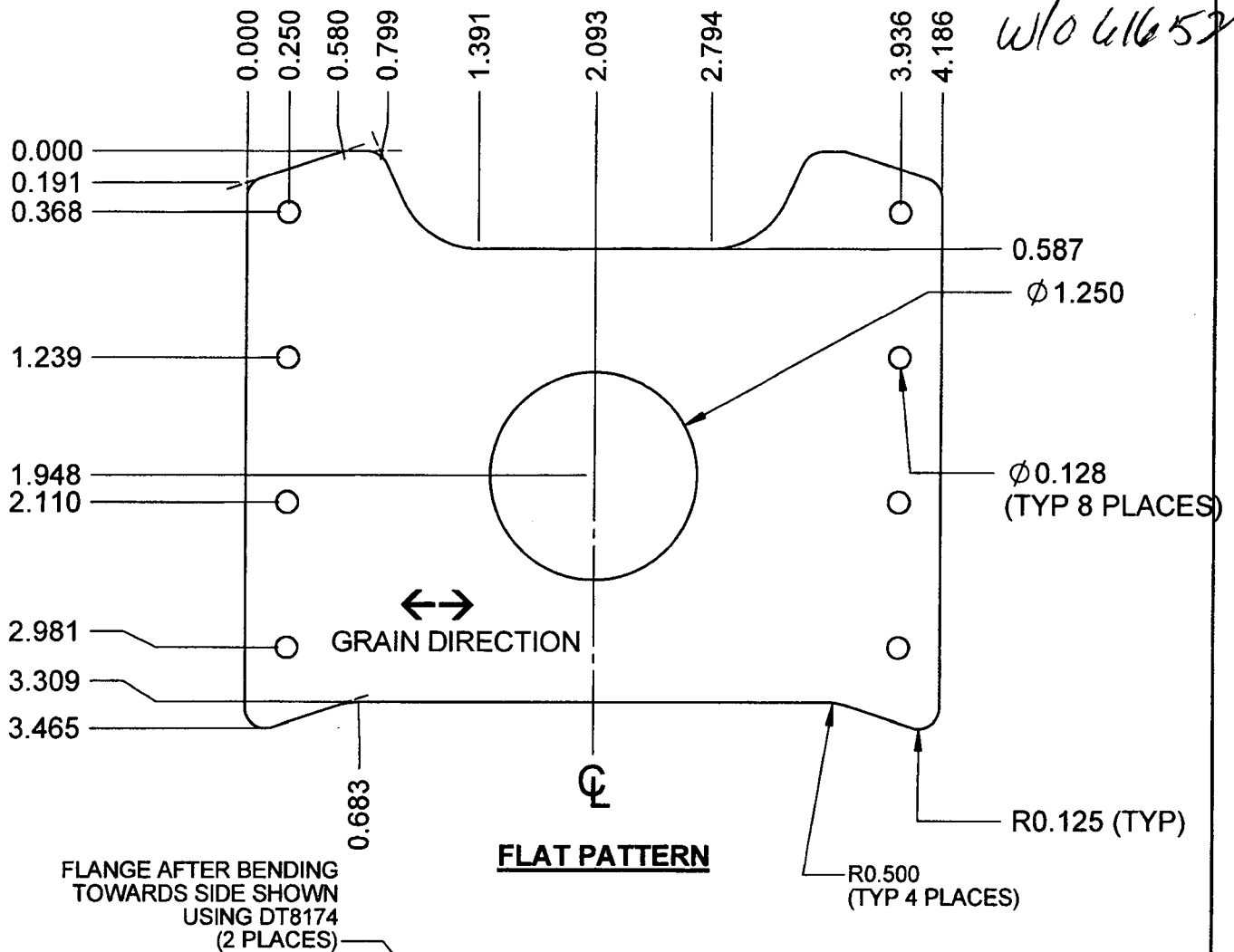
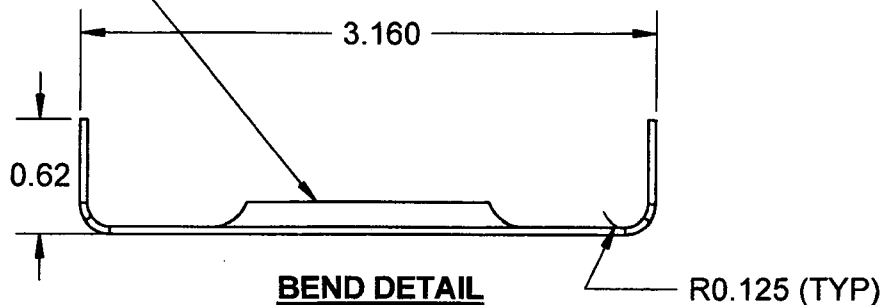
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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 2 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1

**RELEASED***ef. de-20***D3065-1 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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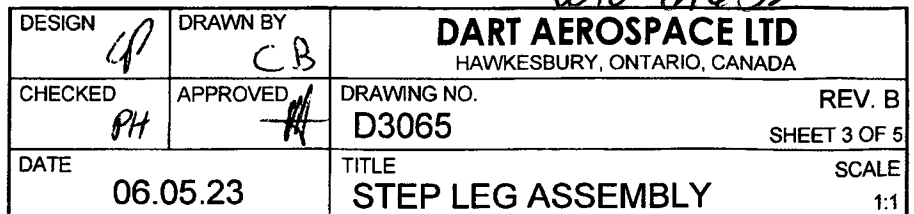
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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-
- BEND DETAIL**
- 24T3S 040)
- R0.125

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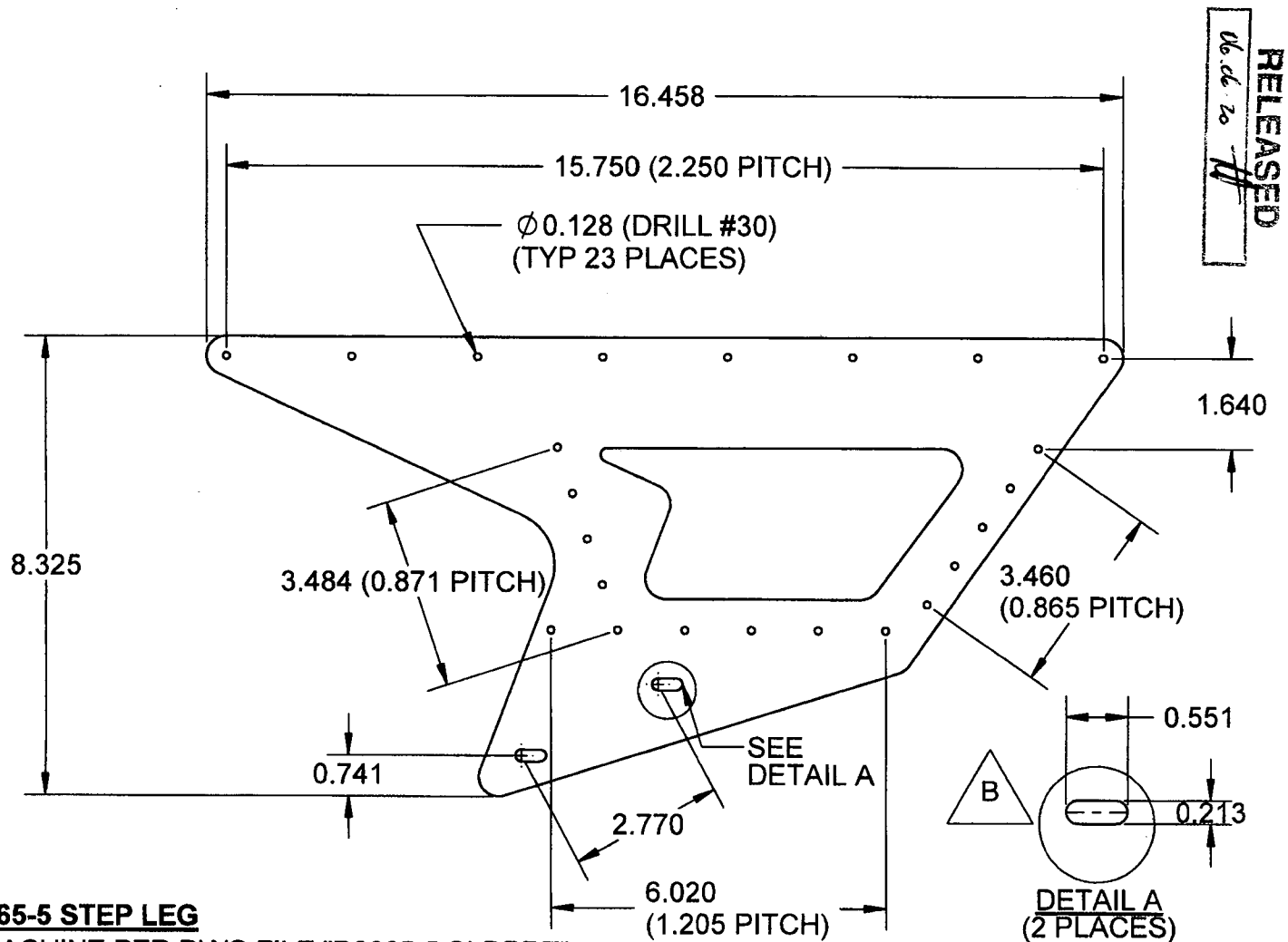
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DART

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CHECKED	<i>PH</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	REV. B
				D3065	SHEET 4 OF 5
DATE	06.05.23	TITLE		STEP LEG ASSEMBLY	
		SCALE		1:3	



D3065-5 STEP LEG

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK
(REF DART SPEC M6061T6S.080)
OR
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
4) BREAK ALL SHARP EDGES 0.005 TO 0.010
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
6) ALL DIMENSIONS ARE IN INCHES

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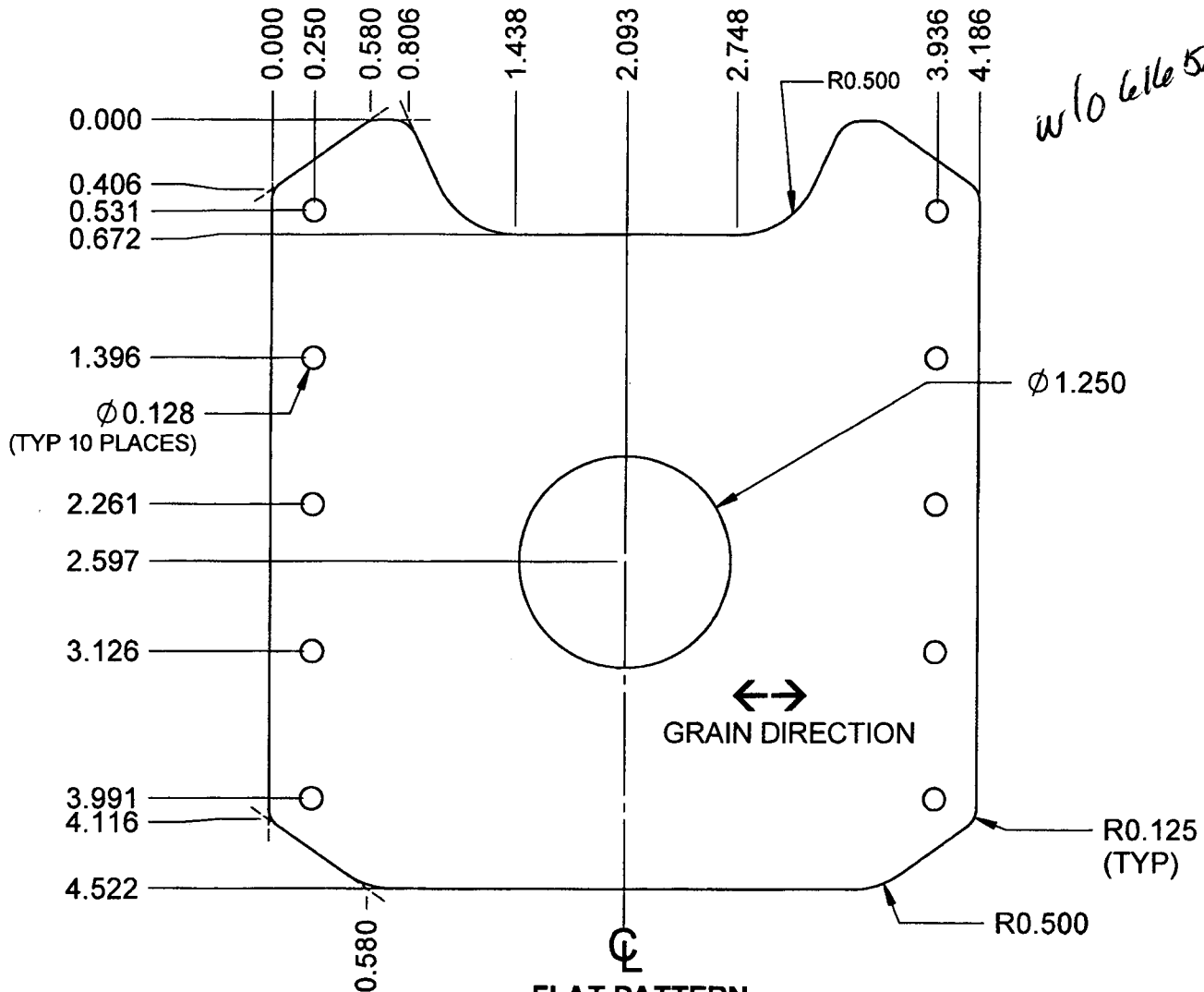
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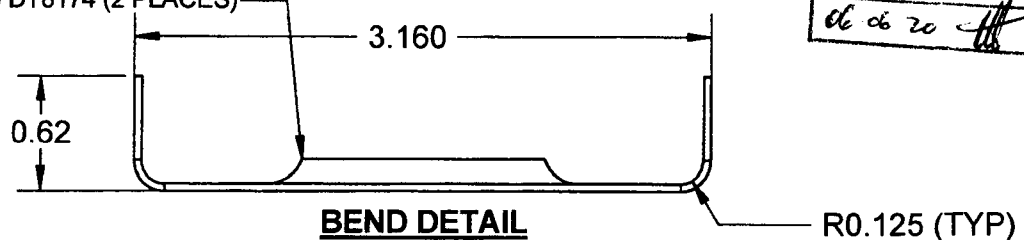
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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 5 OF 5
DATE 06.05.23	TITLE STEP LEG ASSEMBLY		SCALE 1:1



FLANGE AFTER BENDING TOWARDS
SIDE SHOWN USING DT8174 (2 PLACES)

FLAT PATTERN



BEND DETAIL

RELEASED*06 06 20*

D3065-7 STEP SPACER

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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